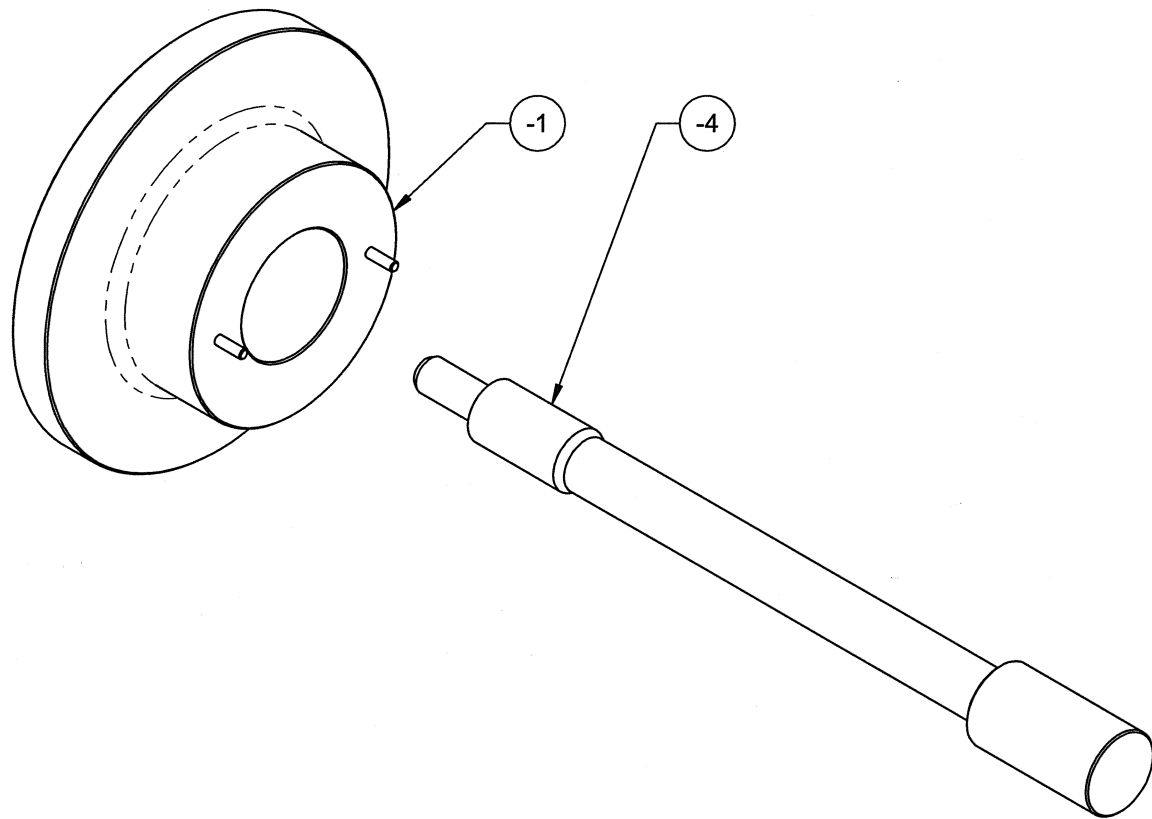


ITEM #	QTY	PART #	PART TITLE
-1	1	RBW6405G00631-3G-1	HUB ASSY
-4	1	RBW6405G00631-3G-4	PIN



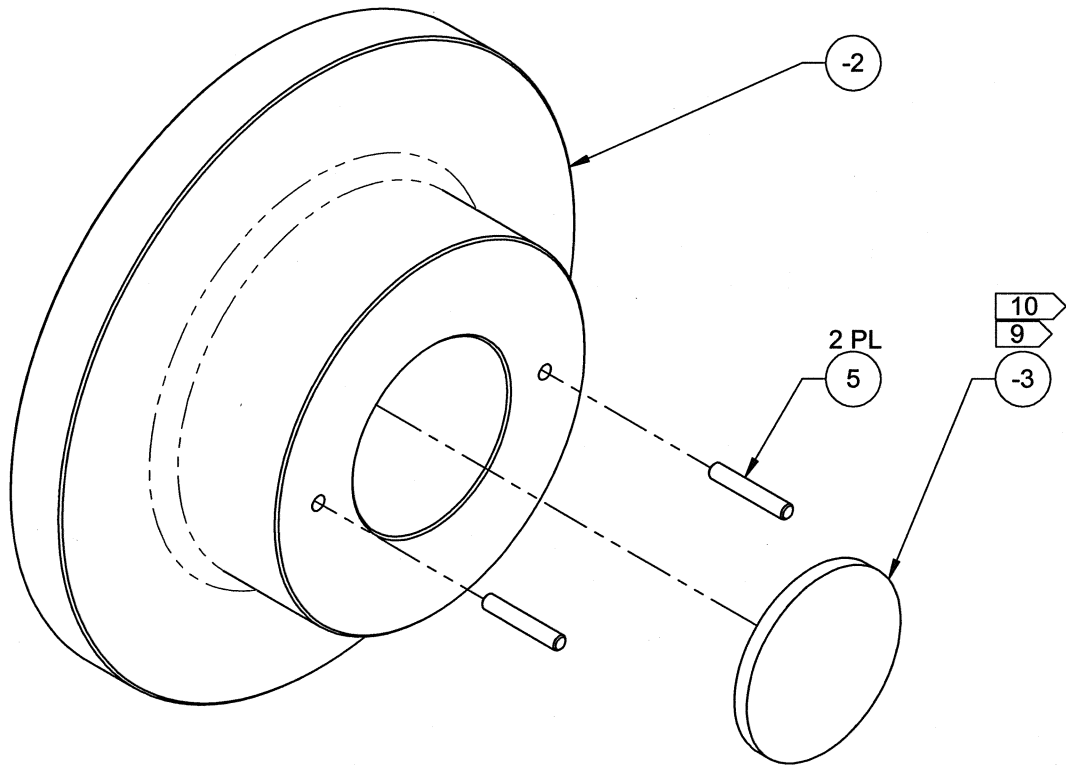
RBW6405G00631-3G T/R DUPLEX BEARING REMOVAL

7

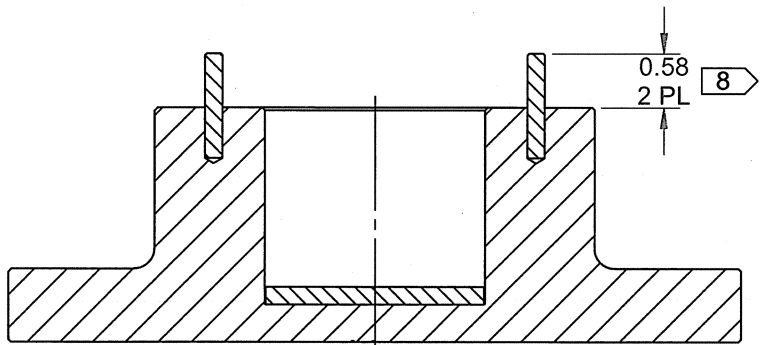
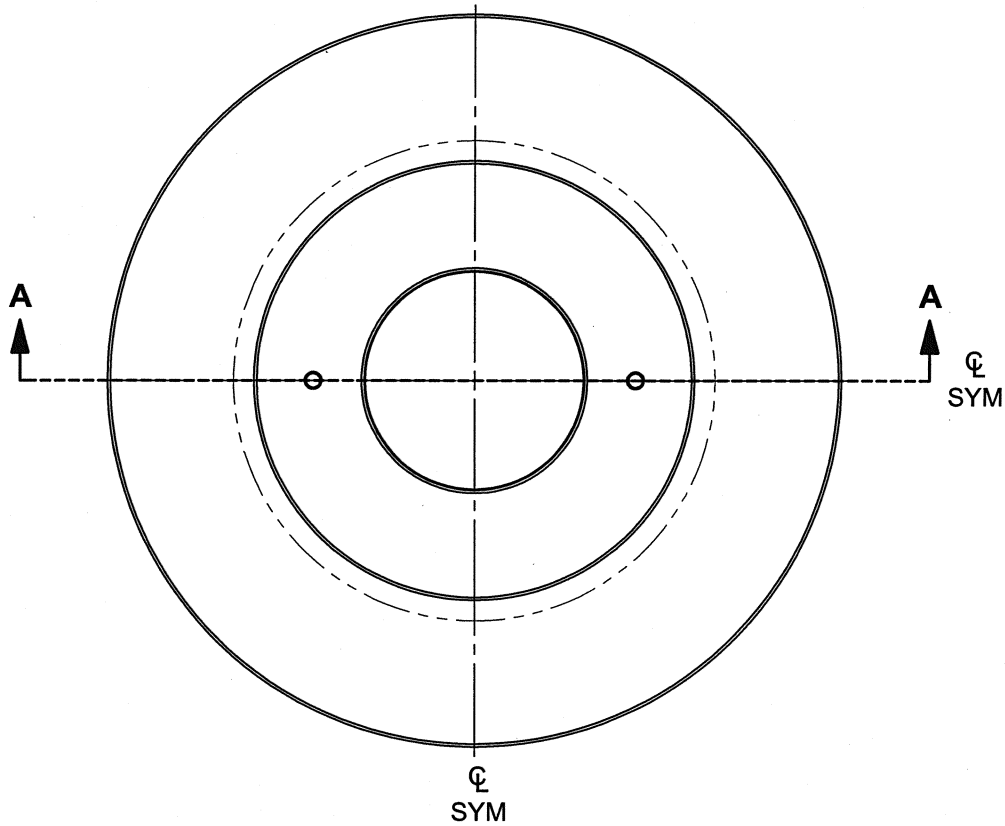
NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: N/A
7) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

B	SEE PREVIOUS PDF FOR OLDER REV TEMPLATE UPDATED PER DART HBY STANDARDS ITEM -1 CHANGED FOR -2 ITEM -1 ASSY ADDED ITEM -3 CHANGED FOR -4 ITEM -5 McMaster#98381A511 CHANGED FOR McMaster#97395A474 ITEM -7 CHANGED FOR ITEM -3 McMaster#1374N16 ITEM -1 DIMENSION .582 CHANGED FOR .58 ITEM -2 DIMENSION 0.1875/0.1870 B.C. 3.456 DEPTH .543 CHANGED FOR 0.1875/0.1867 B.C. 3.456 +/- .001 DEPTH .54, 0.03 x 45° CMF 4 PL ADDED, R0.015 ADDED, DIMENSION R.220 CHANGED FOR R0.22, DIMENSION 2.362 CHANGED FOR 2.362 +0.005/-0, ENGRAVING "MADE IN USA" AND S/N REMOVED, MATERIAL WAS 6061 CLEAR ANODIZE IS 6061/7075 RED ANODIZE ITEM -3 DRAWING ADDED, DIMENSION 2.36 CHANGED FOR 2.34 ITEM -4 DIMENSION .668 CHANGED FOR .660, ENGRAVING REMOVED, DIMENSION 1.539 CHANGED FOR 1.54, R0.008 MAX ADDED, DIMENSION R.017 CHANGED FOR R0.02, MATERIAL WAS 6061 CLEAR ANODIZE IS 6061/7075 RED ANODIZE		VM
	REV.	DESCRIPTION	ECN #
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. B
MFG. APPR.	DP	RBW6405G00631-3G	SHEET 1 OF 5
APPROVED	VM	TITLE	SCALE
DATE 3/1/2019		T/R DUPLEX BEARING REMOVAL	NTS
COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

ITEM #	QTY	PART #	PART TITLE
-2	1	RBW6405G00631-3G-2	HUB
-3	1	RBW6405G00631-3G-3	PLUG
5	2	McMaster#97395A474 OR EQUIV	SS316 DOWEL PIN 3/16" DIA. x 1-1/8" LG.



RBW6405G00631-3G-1 HUB ASSY



SECTION A-A

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEMS 5 WITH ITEM -2, AND REMOVE EXCESS
 - 9) APPLY INSTANT ADHESIVE LOCTITE 495 BETWEEN THE SURFACES OF ITEM -3 AND ITEM -2 IF NECESSARY, AND REMOVE EXCESS
 - 10) ASSEMBLE ITEM -3 ADHESIVE SIDE ON ITEM -2 AS SHOWN, AND CUT EXCESS IF NECESSARY

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	TOOL PART #	REV. B
MFG. APPR.	DP	RBW6405G00631-3G	SHEET 2 OF 5
APPROVED	VM	TITLE	SCALE
DATE	3/1/2019	T/R DUPLEX BEARING REMOVAL	NTS
COPYRIGHT © 2019 BY DART AEROSPACE LTD			
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8

7

6

5

4

3

2

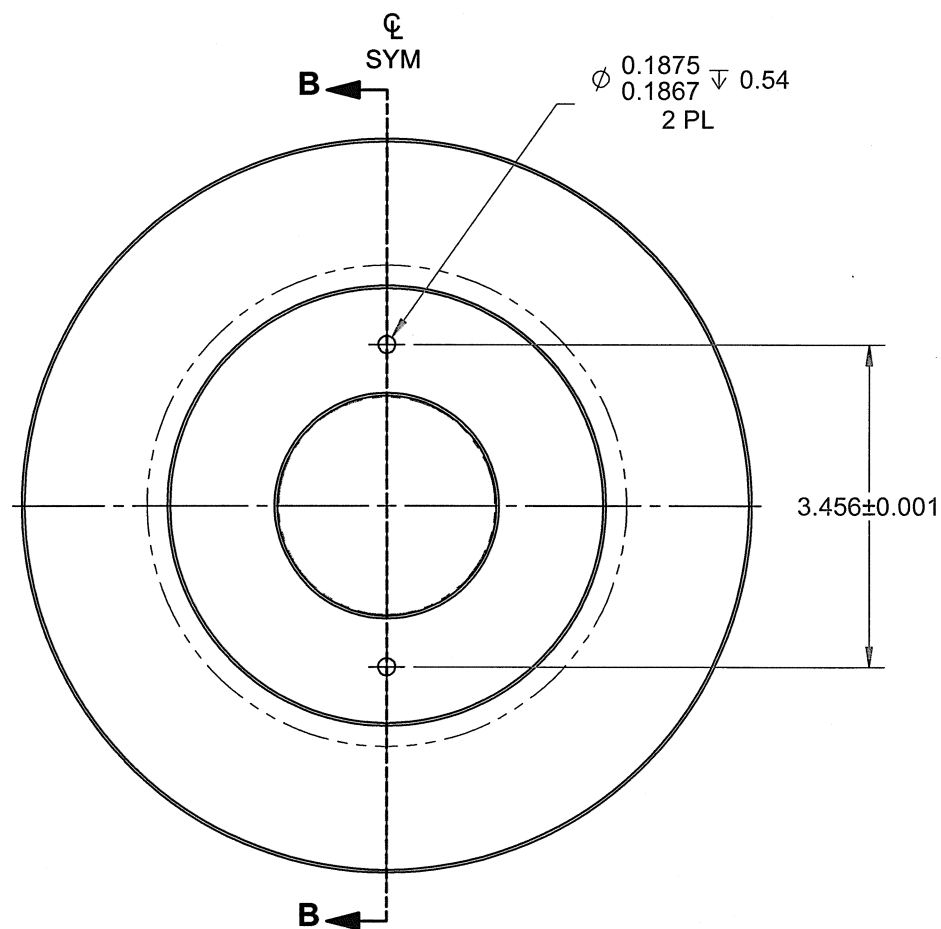
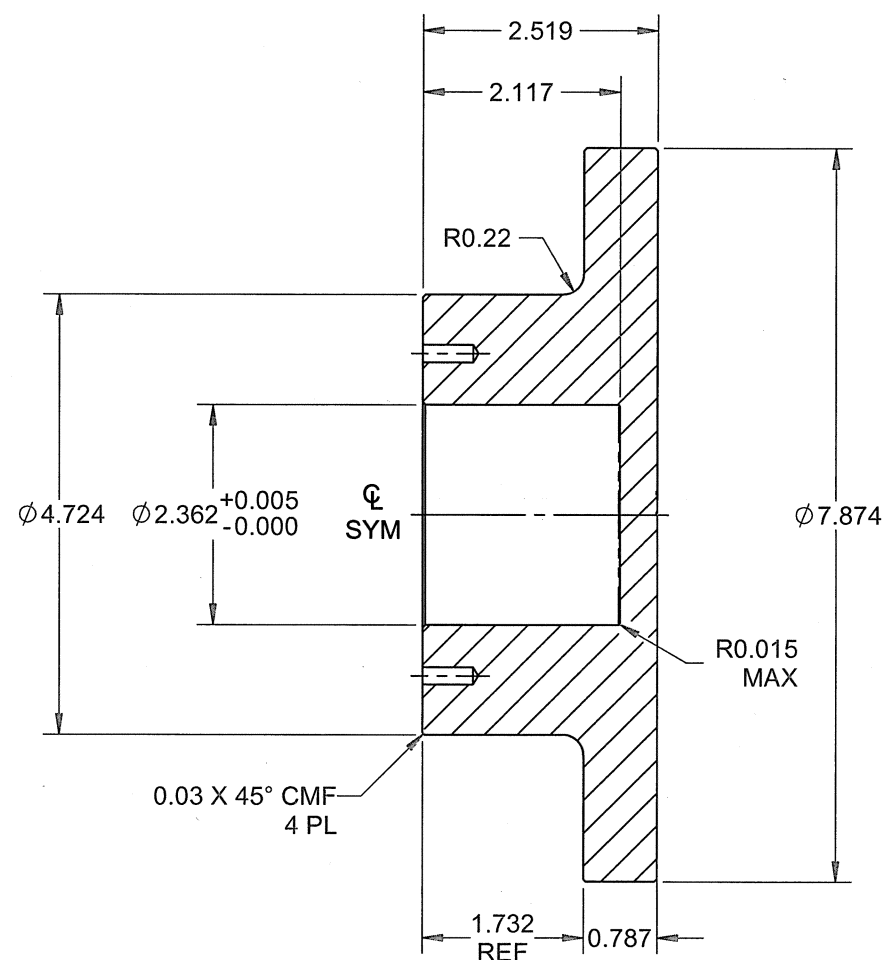
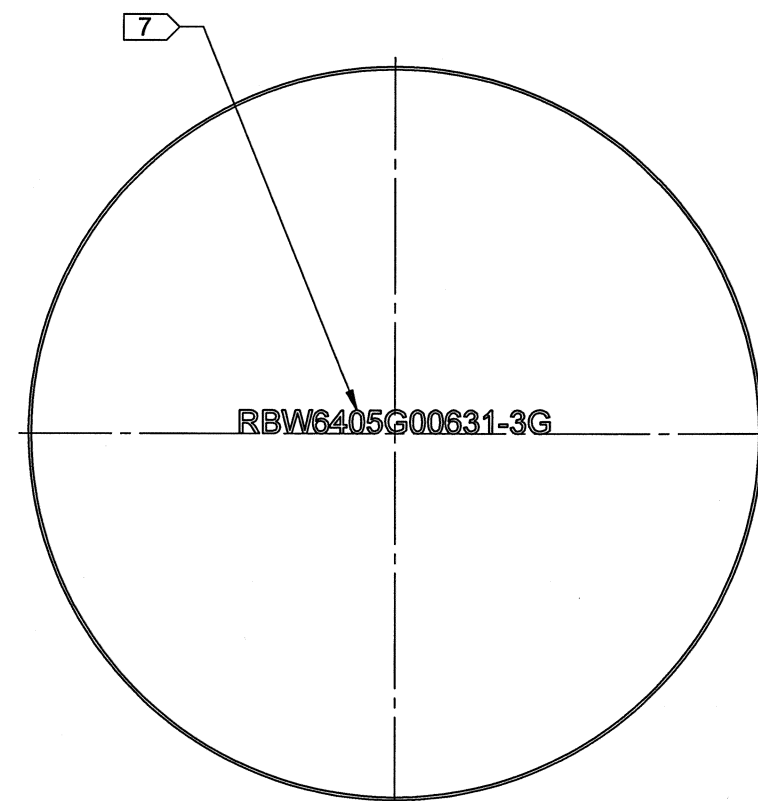
1

D

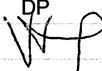

C

B

A

**RBW6405G00631-3G-2 HUB****SECTION B-B****NOTES:**

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	TOOL PART #	REV. B
MFG. APPR.	DP	RBW6405G00631-3G	SHEET 3 OF 5
APPROVED		TITLE	SCALE
		T/R DUPLEX BEARING REMOVAL	NTS 
DATE 2019-09-11		COPYRIGHT © 2019 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8

7

6

5

4

3

2

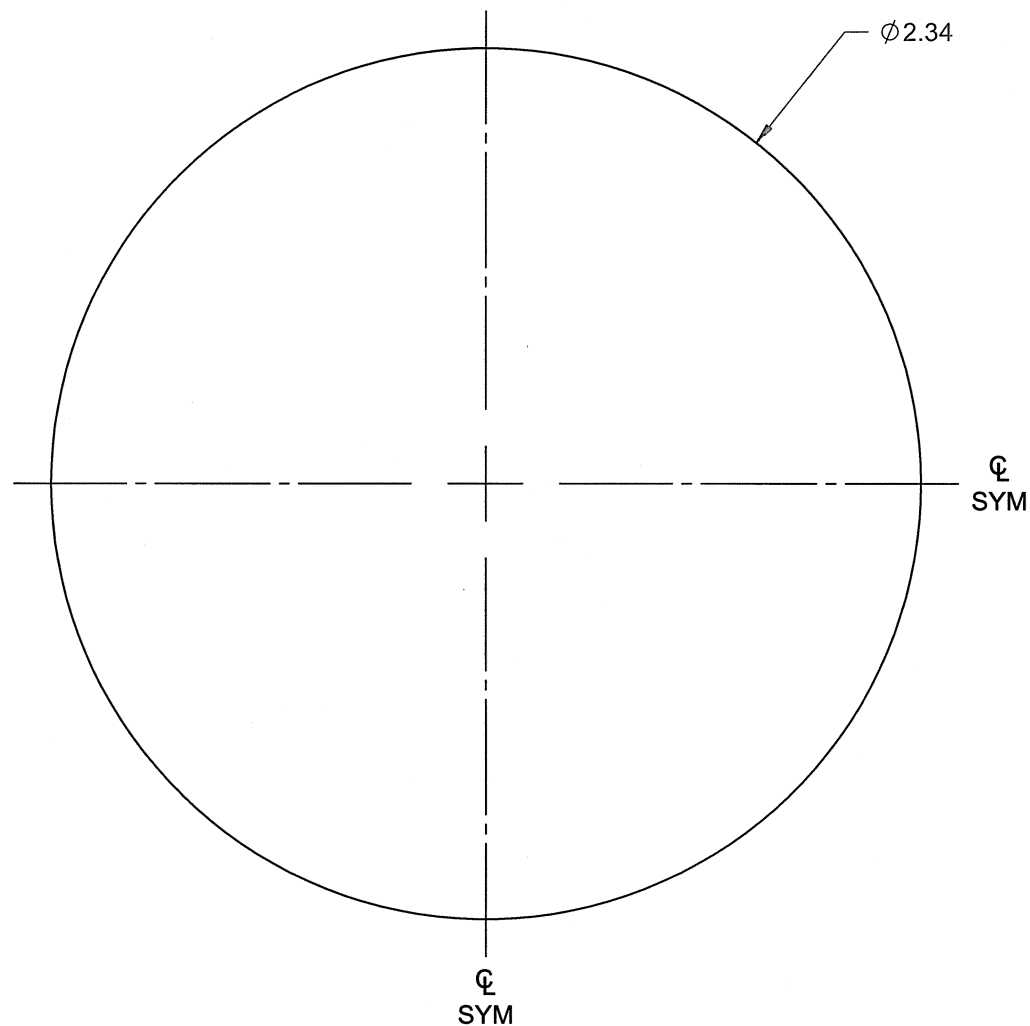
1

D

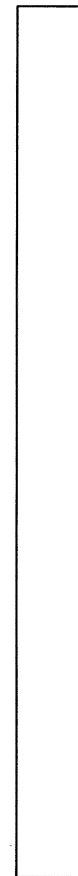
C

B

A

**RBW6405G00631-3G-3 PLUG****NOTES:**

- 1) MATERIAL: McMaster#1374N16 OR EQUIV (MULTIPURPOSE NEOPRENE RUBBER SHEET ADHESIVE BACK 3/16" THK. 50A DURO)
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A

0.19
REF

D

C

B

A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	TOOL PART #	REV. B
MFG. APPR.	DP	RBW6405G00631-3G	SHEET 4 OF 5
APPROVED	VP	TITLE	SCALE
DATE	3/1/2019	T/R DUPLEX BEARING REMOVAL	NTS
COPYRIGHT © 2019 BY DART AEROSPACE LTD			
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1

D

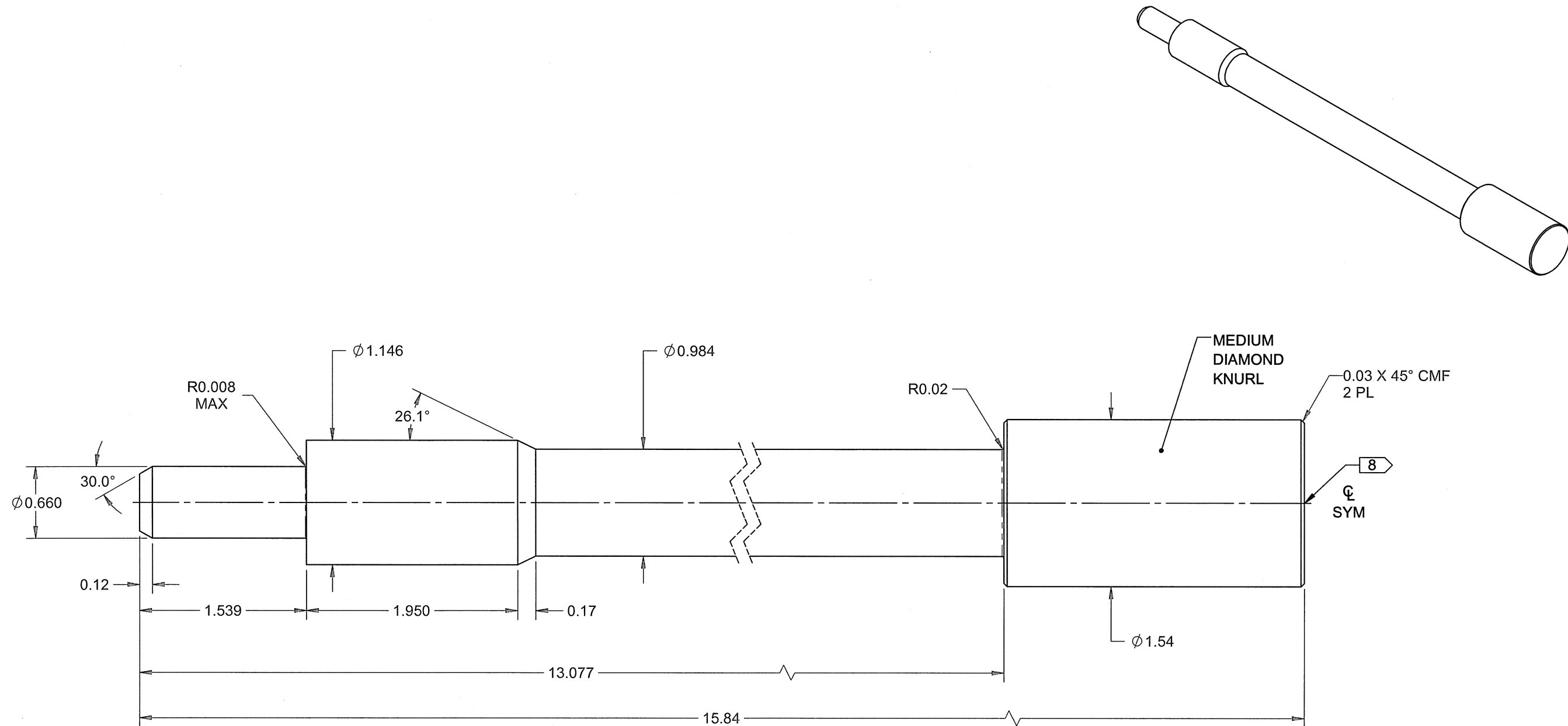
D

C

C

B

B



RBW6405G00631-3G-4 PIN

NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. B
MFG. APPR.	DP	RBW6405G00631-3G	SHEET 5 OF 5
APPROVED	VM	TITLE	SCALE
DATE 3/1/2019		T/R DUPLEX BEARING REMOVAL	NTS
COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1